

Work Order ID 53451

Page 1

November 6, 2009 8:17:26 AM

Item ID: D3067-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: End Plate

Start Date: 05/11/2009 Start Qty: 60.00



Cust Item ID:

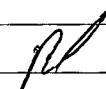
Required Date: 13/11/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan:



Date: 09/11-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3067	Rev A	

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3067

 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

B 9-11-10

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-11-10

120



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

89

Counted

 09.11.11

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November 6, 2009 8:17:27 AM

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Accept



Setup Start



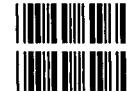
Revision ID: A

Stop



Item Name: End Plate

Start Date: 05/11/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

Brake NC

Memo

Brake NC

Bend as per Dwg D3067

140



QC5- Inspect part completeness to step on W/O

QC

Quality Control

Memo

0.00

88 09/11/16

89

8

Control
(x 88) f

150



Identify as per dwg & Stock Location: WA

Packaging

Packaging

Memo

0.00

0.00

Mo 09.11.16

89

f

Work Order ID 53451

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November 6, 2009 8:17:27 AM

Item ID: D3067-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: End Plate

Start Date: 05/11/2009 Start Qty: 60.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C20911116

Picklist Print

Page 1

November 6, 2009 8:17:31 AM

Work Order ID: 53451



Parent Item: D3067-1RevA



Parent Item Name: End Plate

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		100	sf	129.3237	3.9474	6.		189-11-10

5052-H32 .063 Sheet

Warehouse

Location

Main Warehouse

MAT	129.3237
103755	1.3237
107276	32
112442	96

88

107276

DART AEROSPACE LTD	Work Order:	S3451
Description: END PLATE	Part Number:	D3067-1
Inspection Dwg: 3067-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 9-11-10	Date: 10-11-11	Date: N/A

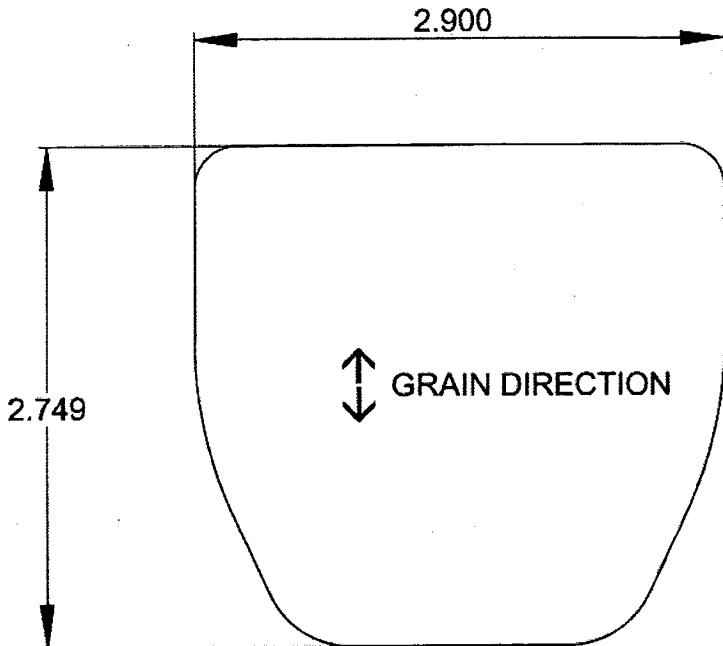
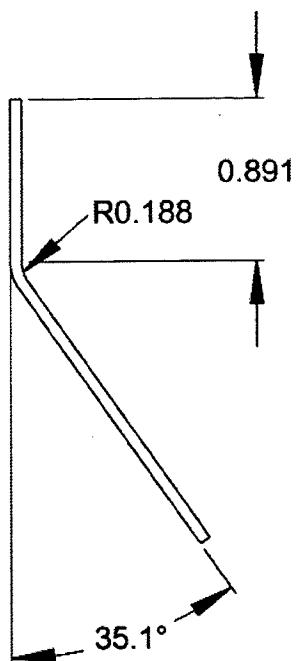
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>HP</i>	APPROVED <i>HP</i>	DRAWING NO. D3067
DATE 02.09.11	TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE

RELEASED

02.09.2011

D3067-1 FLAT PATTERND3067-1 BEND DETAIL

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 33451
B7 09-11-5

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES